

Date: Wednesday, 9/13/2006 4:20:49 PM
 User: Kim Johnston

Process Sheet

Split
SB 06/11/06

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
 Job Number : 28508
 Estimate Number : 10824
 P.O. Number : *N/A* Part Number : D412630032
 This Issue : 9/13/2006 S.O. No. : *N/A* Drawing Number : D412-630 REV.J, P17
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : *J*
 Previous Run : 28153 Material : *N/A*
 Due Date : 10/10/2006 Qty: *3* Um: *2* Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : EST. REV. A 05.11.21 NEW ISSUE EC
 EST. REV. B 05.12.19 updated pick list EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

KS 06.09.20

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

x2
ml 07/01/18

3.0 D3463042 Step Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	<i>B28534</i>

x3

ml

4.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	<i>B29289 x2</i> <i>B28115 x1</i>

ml

5.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	<i>B28527 x2</i> <i>B28164-A x1</i>

ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QA: N/C Closed: _____ Date: _____

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Machine Or Operation:

Description :

6.0

D34439

PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3443-9	Pin

Batch

B29673 x 5
B28166 x 1

ml

7.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	AN4CH3	BOLT
A/R	MS20995c25e	Lockwire

Batch

M19390 x 6 (~~800~~)
M101537

B241

ml

8.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN4C14	BOLT

Batch

M19096 x 3

ml

9.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-7	Bushing

Batch

B28170 x 6

ml

10.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN310-4	Nut

Batch

M19356 x 3

M19096 x 3

ml

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Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	<u>M102073</u> x3

ml

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	<u>B28171</u> x6

ml

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	<u>M30308</u> x2 <u>B25536</u> x1

ml

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	<u>M19096</u> x3

ml

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	<u>M16941</u> x3

ml

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/01/23 (2)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	<i>D28167</i> ✓

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	<i>D30223</i> ✓

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	<i>D28169 1X</i> ✓ <i>B30224 3X</i> ✓

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
6	D3455-1	Spacer	<i>D28171</i> ✓

CP 10/04/23 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-3	Spacer	B28172 ✓

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3462-042	Bracket ass'y	B28472 ✓

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	M19356 ✓

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-5	Nut	M19096 ✓

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	M101692 ✓

CP 04/04/2006

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN44-C12	Eyebolt	M102198 ✓

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	M103248 ✓

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	M19096 ✓

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	M19213 ✓

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 21.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	M101064 ✓

EP 04/01/230

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C516	Washer	M17697 ✓

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	MS21043-3	Nut	M102545 ✓

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-227	COTTER PIN	M102073 ✓

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-229	COTTER PIN	M19086 ✓

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H5	Washer	M10264 ✓

EPB 04/01/23 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Test fit on aircraft in Eng. lab.

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

Draft

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

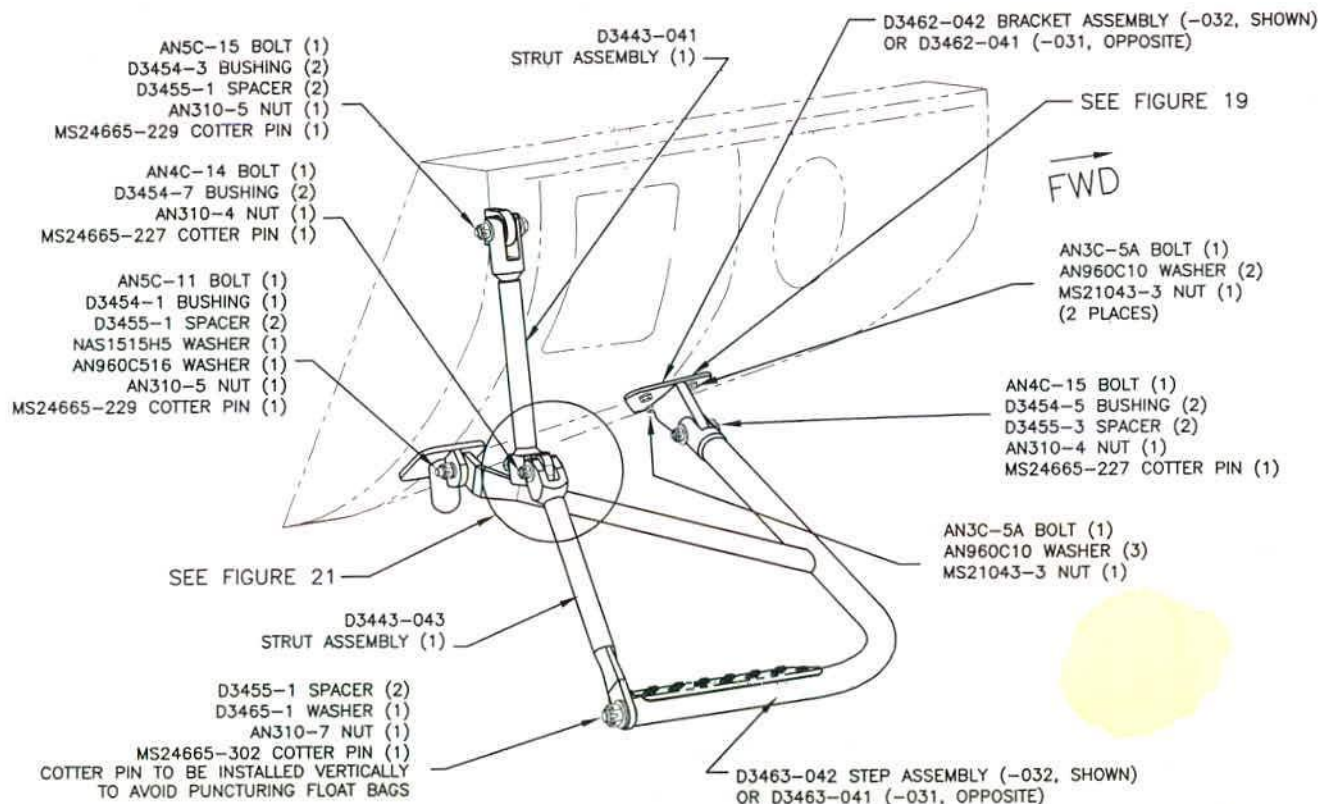
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

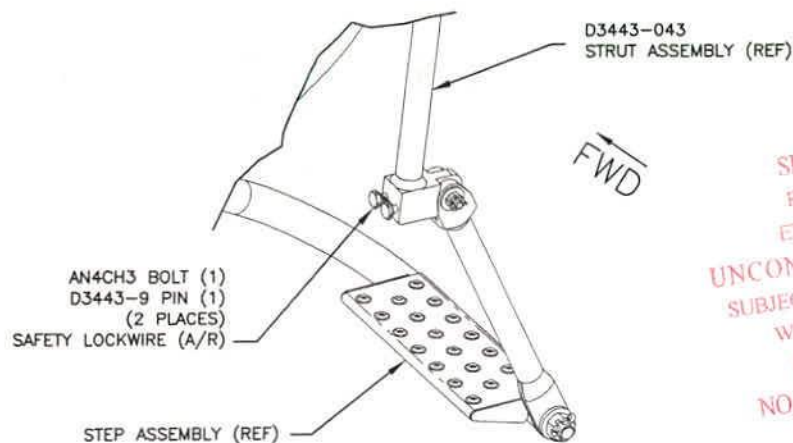
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**FIGURE 20 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 21 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



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Revision: J
Date: 05.12.08